

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025470**Date Inspected:** 05-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Steve Mc Connell and John Paglieri			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	SAS Tower	

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At Tower Base Elevation 13Meters, Electro Slag Welding (ESW) T-joint E-042 location 'K', QA randomly observed ABF/JV qualified welder Richard Garcia perform CJP groove welding repair on the welded cover due to ABF QC noted overlap at approximately Y=9170mm to Y=9780mm. The welder has ground and removed the overlap then tested by QC Steve Mc Connell using Magnetic Particle Testing (MT) with affirmative result. The removal was verified by this QA and obtained same result. The welder was observed welding in the 3G (vertical) position utilizing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1001-Repairs. The weld cover repair was preheated to more than 300 degree Fahrenheit using propylene gas torch prior welding. During the shift, ABF QC John Pagliero was noted monitoring the welder. Measured welding parameter during welding was 125 amperes. At the end of the shift, 3G SMAW weld cover repair was still continuing and should remain tomorrow.

At Tower Base Elevation 13Meters, Electro Slag Welding (ESW) T-joint E-043 location 'Q', QA randomly observed ABF/JV qualified welder Jeremy Dolman perform CJP groove welding repair on the welded cover due to ABF QC noted overlap at approximately Y=9475mm to Y=9780mm. The welder has ground and removed the overlap then tested by QC Steve Mc Connell using Magnetic Particle Testing (MT) with affirmative result. The removal was verified by this QA and obtained same result. The welder was observed welding in the 3G (vertical) position utilizing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing

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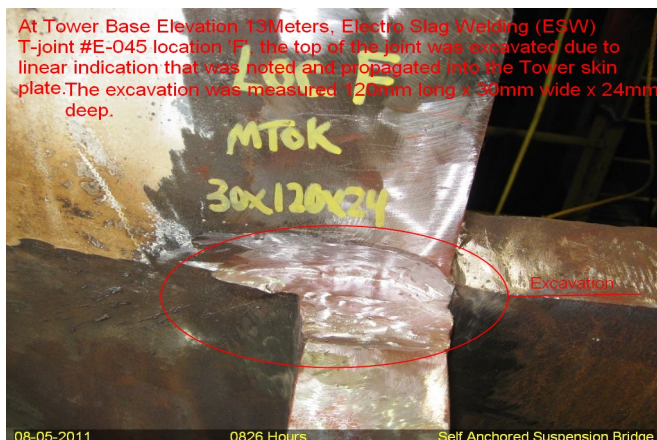
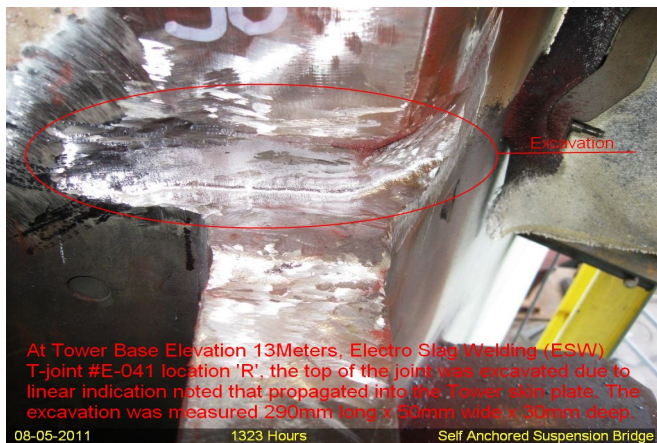
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welding procedure ABF-WPS-D15-1001-Repairs. The weld cover repair was preheated to more than 300 degree Fahrenheit using propylene gas torch prior welding. During the shift, ABF QC John Pagliero was noted monitoring the welder. Measured welding parameter during welding was 120 amperes on a 1/8" diameter E7018H4R electrode. At the end of the shift, 3G SMAW weld cover repair was completed.

At Tower Base Elevation 13Meters, Electro Slag Welding (ESW) the following ESW weld locations where run off tab removed and noted with linear indications were excavated using carbon air arc gouging followed by die grinder. While ABF personnel were excavating the indications, ABF QC was also noted performing Magnetic Particle Testing (MT) to confirm the removal of the indications. After the removal and confirmation from ABF QC, this QA also performed verification on the complete removal of the linear indications. The following ESW weld locations were excavated, MT tested by ABF QC and MT verified by this QA;

ESW Weld Location Excavation Dimension (L x W x D) QA MT

1. 'E' (N-045) 125mm x 25mm x 25mm MT Passed
2. 'F' (E-045) 120mm x 30mm x 24mm MT Passed
3. 'R' (E-041) 290mm x 50mm x 30mm MT Passed
4. 'S' (S-041) 210mm x 50mm x 30mm MT Passed
5. 'Q' (E-043) Top one foot only MT Passed
6. 'K' (E-042) Top two feet only MT Passed



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Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo, Joselito
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Quality Assurance Inspector

Reviewed By:	Levell, Bill
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QA Reviewer
